

Work Order ID 88567***88567***

Page 1

August-02-12 1:01:50 PM

Item ID: D350-721-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Clamp Assembly

Start Date: 7/27/12 Start Qty: 1.00

1

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: 

Date: 12083

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
DSI9486	A								
IIN D350-721	B								
100		0.00							
100									
DC		0.00							
Document Control	Memo								
	Photocopy bluefile & type labels per PPP D350-721-011 / DSI 9486								
	CHG001								
110	Pick Kit	0.00							
110									
Packaging	Memo	0.00							
Packaging									

DAS
16
12/16/17
JB

SD

12/09/12 f0

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data											
Equip/Tooling											
Operator											
Material											
Setup											
Other											
Process											
Supplier											
Training											
Unapproved											
FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Work Order ID 88567***88567***

Page 2

August-02-12 1:01:50 PM

Item ID: D350-721-011

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Basket Clamp Assembly

Start Date: 7/27/12 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 8/17/12 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:

Run Start ***NR1***

QC: Date: SPC (Y/N): Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

120

QC4- 100% Inspect kits for completeness

0.00

120

QC

Memo

0.00

Quality Control

130

0.00

130

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D350-721-011 / DSI 9486

Location:

PPP rev: Draft

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

Closed 13/12/13

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											
FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

Picklist Print

August-02-12 1:01:50 PM

Page 1

Work Order ID: 88567

Parent Item: D350-721-011

Parent Item Name: Basket Clamp Assembly

Start Date: 7/27/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2230-1 Lug		Manufactured	No			110	Each	188.0000	3	3	✓ go		sf
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST480		188							
				84136		188			84136				
D2230-3 Lug		Manufactured	No			110	Each	226.0000	4	4	✓ go		sf
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST472		200							
				84134		200							
				ST480		26							
				83261		2							
				84133		24							
D2732 Rubber Extrusion		Manufactured	No			110	f	385.2500	2	2	✓ go		sf
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST410		385.25							
				70987		0.3							
				83560		384.95			83560				
AN4-15A Bolt		Purchased	No			110	Each	288.0000	8	8	✓ go	12/09/12	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				358		100							
				121652		100							
				GA		100							
				120449		100							
				ST358		88							
				118706		3							
				120422		1							
				122141		84							

Qty x 8 per kit
D3-011 → maxstream 8/17/2017

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											

FAULT CATEGORY				
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube	General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio	☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions	☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge	☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other

Picklist Print

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Page 2

Work Order ID: 88567

Parent Item: D350-721-011

Parent Item Name: Basket Clamp Assembly

Start Date: 7/27/12

Required Date: 8/17/12

Start Qty: 1.00

Required Qty: 1.00

AN960JD416 Washer Purchased No

NAS1149D0463J

110 Each 29.0000

16

16

122452 20

Location

Loc Qty

Loc Code

ST351

29

116289

8

119097

21

MS21042L4 Nut Purchased No

110 Each 5,799.0000

8

8

122452 20 12/09/12

Location

Loc Qty

Loc Code

314

5000

122452

5000

ST300

799

104248

1

116823

8

119075

116

121011

193

121444

481

122452

1

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Shop Packet Print

Page 2

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Crosstube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data ☐											
Equip/Tooling ☐											
Operator ☐											
Material ☐											
Setup ☐											
Other ☐											
Process ☐											
Supplier ☐											
Training ☐											
Unapproved ☐											
FAULT CATEGORY											
Landing Gear ☐ Bending ☐ Centre Not Concentric to O/S ☐ Cracks ☐ Crushed/Crimped ☐ Cuffs ☐ Heat Treat ☐ Inspection Strip in Tube ☐ Ripples in Bend ☐ Torque Waves in Extrusion ☐ Turning Sequence ☐ Wave/Twist in Tube			General ☐ Bend ☐ BOM/Route ☐ Broken/Damaged ☐ Burrs ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Drill Holes ☐ Drawing ☐ Finish ☐ Folio			☐ Grain ☐ Hardware ☐ Inspection Incomplete ☐ Instructions Incomplete/Unclear ☐ Maintenance ☐ Mislabeled ☐ Misread ☐ Offset ☐ Out of Calibration ☐ Out of Sequence ☐ Outside Dimensions			☐ Ovalized ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Positioned Wrong ☐ Power Loss/Surge ☐ Pressure/Forced ☐ Temperature/Cure ☐ Weld ☐ Wrong Stock Pulled ☐ Other		

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D407-802 Rev. A AND
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D407-802 REV. 0

REF CANADIAN STC: SH10-44

REF FAA STC: SR02933NY

REF EASA STC: 10033253

1.0 PURPOSE:

The purpose of this service instruction is to allow customers to substitute their standard D3552-XX door props with stronger door props in accordance with DSI 9586-YYY kits in tables below for cases where the doors are heavier than normal.

2.0 INSTALLATION AND MAINTENANCE:

Replacement door prop is installed and maintained in accordance with ICA-D407-802.

3.0 WEIGHT AND BALANCE:

This change has negligible effect on weight and balance

4.0 PARTS LIST:

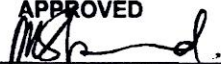
Qty -011	Part Number	Description
☒	DSI 9586-011	DOOR PROP UPGRADE KIT
1	D3552-15	DOOR PROP (REPLACES D3552-17)

Qty -013	Part Number	Description
☒	DSI 9586-013	DOOR PROP UPGRADE KIT
1	D3552-25	DOOR PROP (REPLACES D3552-27)

88567
PL 12-08-3

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 11.12.07
CERT. NO.: SH10-44
ISSUE NO.: 1

A	NEW ISSUE	AP	11.12.07
REV.	DESCRIPTION	BY	DATE
DESIGN	AP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9586	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOOR PROP UPGRADE KIT	NTS
DATE	11.12.07	COPYRIGHT © 2011 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

6.0 PARTS LIST

Qty -011	Qty -041	Qty -043	Qty -045	Qty -046	PART NUMBER	DESCRIPTION
X					D350-721-011	BASKET CLAMP KIT
	X				D350-721-041	LIGHTWEIGHT HELI- UTILITY-BASKET™
		X			D350-721-043	LIGHTWEIGHT HELI-UTILITY-BASKET™, SHORT VERSION
			X		D350-721-045	MAINTENANCE STEP, LH
				X	D350-721-046	MAINTENANCE STEP, RH
	1				D3324-041	BASKET BASE ASSEMBLY
	1				D3325-041	BASKET LID ASSEMBLY
		1			D3326-041	BASKET BASE ASSEMBLY
		1			D3327-041	BASKET LID ASSEMBLY
	2	2			D2022-101	SPACER
3	3	3			D2230-1	LUG
4	4	4			D2230-3	CLAMP
	1	1			D2332-041	PROP ASSEMBLY
	1	1			D2530	HANDLE ASSEMBLY
	2	2			D2535	SPRING
	2	2			D2537	BUSHING
8	8	8			D2732-030	RUBBER CUSHION
	2	2			D2931	BUMPER
	1	1			D3338-1	LUG
	2	2			D3350-041	STRUT
	1	1			D3351-1	LABEL
			1	1	D3436-041	CLAMP
			1		D3436-043	LH STEP
				1	D3436-044	RH STEP
	2	2			AN3-16A	BOLT
	2	2			AN4-7A	BOLT
	2	2			AN4-12A	BOLT
	4	4			AN4-14A	BOLT
8	8	8			AN4-15A	BOLT
			4	4	AN4-16A	BOLT
	1	1			AN4-20A	BOLT
	1	1			AN4-22A	BOLT
	4	4			AN5-17A	BOLT
			8	8	AN960-416	WASHER
16	30	30			AN960JD416	WASHER
	2	2			AN960JD416L	WASHER
	4	4			AN960JD516	WASHER
	2	2			AN960JD8	WASHER
	4	4			AN970-4	WASHER
			4	4	MS20365-428	NUT
	2	2			MS20600AD4W3	RIVET
	2	2			MS21042L3	NUT (OR MS21042-3)
8	18	18			MS21042L4	NUT (OR MS21042-4)
	4	4			MS21042L5	NUT (OR MS21042-5)

Work Order ID 88567

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88567

Page 1

Item ID: D350-721-011

Revision ID:

Item Name: Basket Clamp Assembly

Start Date: 7/27/12 Start Qty: 1.00

Required Date: 8/17/12 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date: 1208-3

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								

DSI9486

A

IIN D350-721

B

100

100

DC

Document Control

Memo

Photocopy bluefile & type labels per PPP D350-721-011 / DSI 9486
CHG001

JB

MLJ 12/09/12

110

110

Packaging

Packaging

Pick Kit

Memo

Work Order Summary

Monday, June 26, 2017 1:20:56 PM

Page 1 of 1

Criteria : Work Order ID: 88567 Item ID: D350-721-011 Product Family SMALL FAB
Work Order Start Dates 7/27/2012 to 7/27/2012 11:59:59 PM Work Order Required Dates 8/17/2012 to 8/17/2012 11:59:59 PM
All References
Work Order Status Costed

Work Order ID	88567	Required Qty	1.0000	Status Code	Costed
Item ID	D350-721-011	Accepted Qty	0.0000	Scrap Qty	0.0000
Item Name	AS350/AS355 Lightweight Basket Mounting System				
Current Acct Value	\$0.000				
Start Date	7/27/2012	Required Date	8/17/2012	Completed Date	7/16/2014 10:00:22 AM

Standard	** Actual **		** Acct. Value **	** Variance **	** Variance % **
Direct Costs	Total	Each	Each	Each	Each
Material	\$127.025	\$0.000	\$128.523	\$128.523	100.00%
Labor	\$1.607	\$0.000	\$1.273	\$1.273	100.00%
Outplant	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Variable Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
Fixed Burden	\$3.995	\$0.000	\$3.165	\$3.165	100.00%
Material Burden	\$0.000	\$0.000	\$0.000	\$0.000	0.00%
** Total **	\$132.627	\$0.000	\$132.961	\$132.961	

Item ID/Item Name	Required Qty	Issue Code	Issue Date	Issued Qty	Cost Amount
AN4-15A Bolt	8.0000		9/12/2012	8.0000	\$2.376
D2230-1 Mounting Lug	3.0000		9/12/2012	3.0000	\$60.112
D2230-3 Mounting Lug	4.0000		9/12/2012	4.0000	\$60.457
D2732 Rubber Cushion (\$per foot)	2.0000		9/12/2012	2.0000	\$6.579
MS21042L4 Nut	8.0000		9/12/2012	8.0000	\$2.004
NAS1149D0463J Washer	16.0000		9/12/2012	16.0000	\$1.099
Total Matl Amts:					\$132.627